Item ID:	D4074-7		Accept	***N9000401100***	Setup	Start	***NS1***
Revision ID:						Stop	***NS2***
Item Name:	Striker Plate						

| Start Date: | 4/25/13 | Start Qty: 6.00 | ***6*** | Cust Item ID: | | | |
| Required Date: | 4/30/13 | Req'd Qty: 6.00 | ***6*** | Customer: | | | |

Reference:

					Run	Start	***NR1***
Approvals:	Process Plan: _MLJ_	Date: 13-05-01	Tooling: _____	Date: _____		Stop	***NR2***
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4074	C								
100		0.00							
100						6	0		Jm 13-07-25
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304 .050"	Dwg Rev: C								
	Prog Rev: C								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						6	0		Jm 13-07-25
QC	Memo	0.00							
Quality Control									

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: Date:

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

Item ID:	D4074-7			Accept	***N9000040100***	Setup	Start	***NS1***
Revision ID:								
Item Name:	Striker Plate						Stop	***NS2***

Start Date:	4/25/13	Start Qty:	6.00	***6***		Cust Item ID:		
Required Date:	4/30/13	Req'd Qty:	6.00	***6***		Customer:		
Reference:								

Approvals: Process Plan: _____   Date: _____   Tooling: _____   Date: _____   **Run   Start   *NR1***

QC: _____   Date: _____   SPC (Y/N): _____   Date: _____   **Stop   *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 ***120*** QC Quality Control	QC8- Inspect parts - second check Memo	0.00 27 0.00 137-26				6			
130 ***130*** Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				6			Sb 13/07/29
140 ***140*** QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				6 13-07-29			

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐		

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

	General				
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Item ID: D4074-7   Accept   ***N9000401000***   Setup Start ***NS1***

Revision ID:

Item Name: Striker Plate   Stop   ***NS2***

Start Date: 4/25/13   **Start Qty:** 6.00   ***6***   **Cust Item ID:**

Required Date: 4/30/13   **Req'd Qty:** 6.00   ***6***   **Customer:**

Reference:

                                                                                                 Run   Start ***NR1***

Approvals: **Process Plan:** _____ **Date:** _____   **Tooling:** _____ **Date:** _____

                 QC: _____ **Date:** _____   **SPC (Y/N):** _____ **Date:** _____   Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: STO92	0.00							
170 Packaging	Memo	0.00				6X	*M.W.* 13-07-29		
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180 QC	Memo	0.00				MCS 13-07-30			
Quality Control							MCS 13-07-29		

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Picklist Print

April-30-13 2:49:25 PM

Work Order ID:	101107	
Parent Item:	D4074-7	**Start Date:** 4/25/13 **Required Date:** 4/30/13
Parent Item Name:	Striker Plate	**Start Qty:** 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC   IPP REV:B AS PER ECN 11-613
11-07-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	287.6699	0.0103	0.0650526			
304/316 .050 Sheet										0.1		*Jm13-07-25*	

Location	Loc Qty	Loc Code
MAT019	193.3	_____
117188	5	_____
117766	5	_____
120604	5	_____
122325	3	_____
123155	3	_____
124572	172.3	_____
MAT020	94.369894	
120243	2	*120243*
121626	1.529894	_____
124029	90.84	_____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

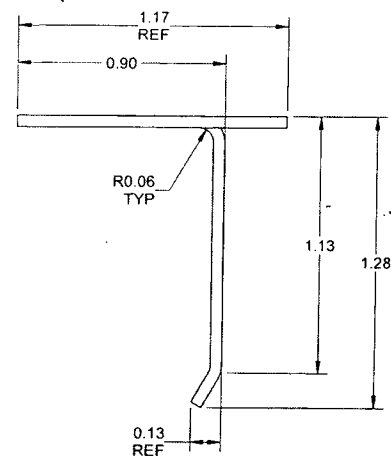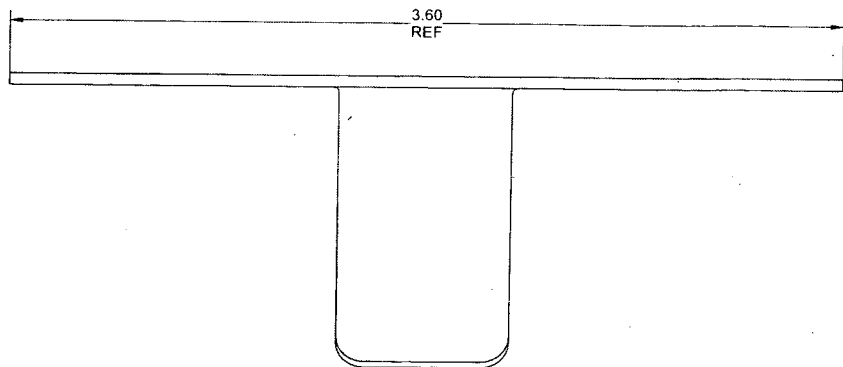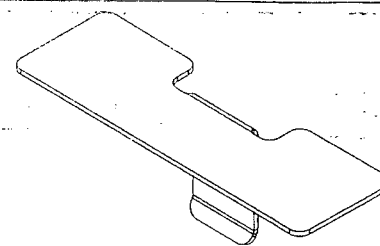| Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.753"	—		V	Jkmoi
1.43	+/-0.030	1.422"	—		V	
0.26	+/-0.030	X.0262"	—		V	
3.60	+/-0.030	3.604"	—		V	
1.17	+/-0.030	1.175"	—		V	
2.10	+/-0.030	2.099"	—		V	
0.050	+/-0.010	0.046"	—		V	

Measured by:	Jm	Audited by:	DAS 27	Preliminary Approval:	
Date:	13-07-25	Date:	13 7 26	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	11.07.26	2.10 was 1.72 per Dwg Rev B	KJ	
C	11.11.07	Dimensions updated per Dwg Rev C	KJ	

10.1107 MLJ
13-05-01

3.60
REF

1.17
REF

0.90

R0.06
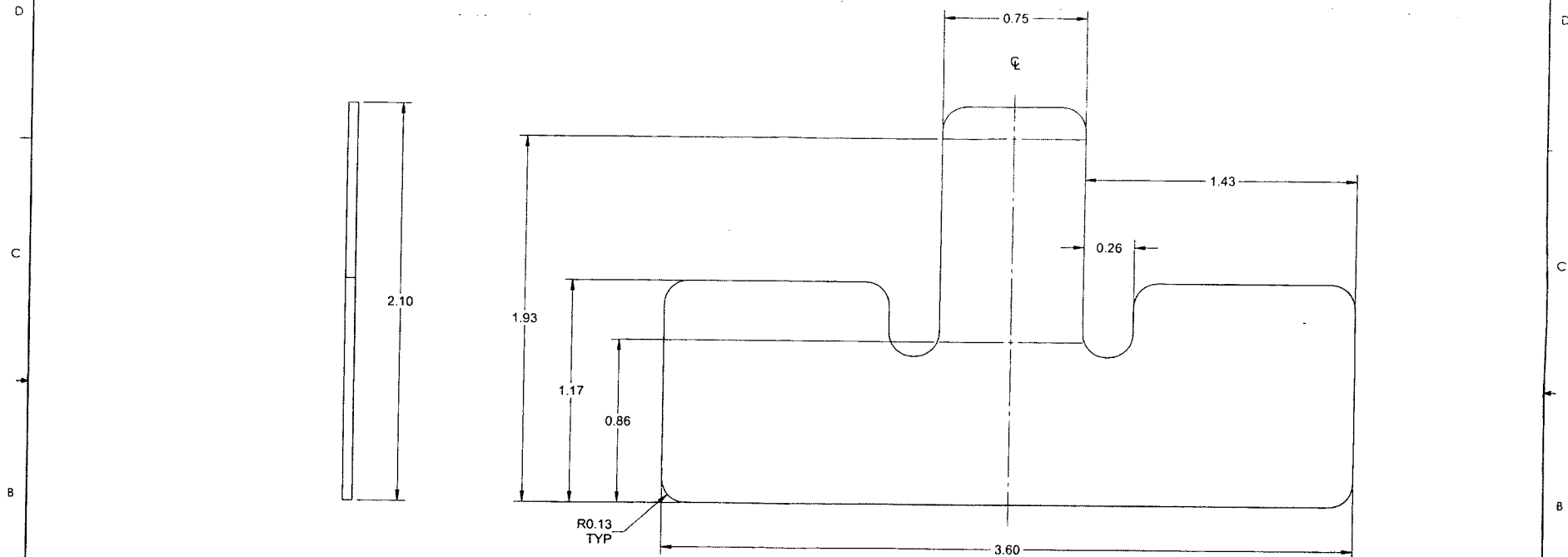TYP

1.13

1.28

0.13
REF

△C **D4074-7 STRIKER PLATE**
(MAKE FROM D4074-7F FLAT PATTERN)

RELEASED
2011-10-26

NOTES:
1) MATERIAL: MAKE FROM D4074-7F FLAT PATTERN
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.07 lbs

DESIGN		**DART AEROSPACE USA, INC.**
DRAWN	RF	KENT, WA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D4074 SHEET 6 OF 7
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
DATE 11.10.12		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

⟨C⟩ D4074-7F FLAT PATTERN

0.75

1.43

0.26

2.10

1.93

1.17

0.86

R0.13
TYP

3.60

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
      0.050 (18 GAUGE) THICK
      OR AMS 5513 (304)
      OR AMS 5524 (316)
      OR ASTM A240
      OR ASME SA240
      REF DART SPEC M3046S18GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.01 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

2011-10-26

		DART AEROSPACE USA, INC.	
DESIGN		KENT, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4074	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.10.12		